

Date: Friday, 7/4/2008 12:48:42 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206/OH-58 SADDLE, INBOARD, LEFT SIDE		
Job Number	40281		Part Number	D29331		
Estimate Number	10833		Drawing Number	D2933 REV C		
P.O. Number	:		Project Number	N/A		
This Issue	7/4/2008	S.O. No. :	Drawing Revision	C		
Prsht Rev.	NC	Type :	Material	:		
First Issue	11	MACHINED PARTS	Due Date	7/30/2008	Qty:	10
Previous Run	39888		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	Saddle Billet
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: B34822
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		 Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		 Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		 Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206/0H-58 SADDLE, INBOARD, LEFT SIDE
Job Number: 40281		Part Number: D29331
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		<i>SDP 08/08/27</i>
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>MF 08/08/27</i>
7.0	POWDER COATING	POWDER COATING  <i>M108S23</i> 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<i>MF 08/08/27</i>
START TIME: <u>2:30</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>3:00</u>		<i>MF 08/08/27</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		<i>MF 08-08-27</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>428A</u>		<i>AS 08082801</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>MF 08-08-28</i>
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	40281
Description: 206 Saddle, Inboard, Left side			Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:			Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.119	.121"	.123	.123	.120
B	0.100	0.140		.119	.121"	.121	.121	.121
C	0.100	0.140		.100"	.132	.134	.136	.135
D	0.210	0.230		.225"	.221"	.219	.219	.221
E	1.245	1.255		1.251	1.250	1.250	1.249	1.250
F	1.245	1.255		1.249	1.250	1.250	1.249	1.250
G	2.495	2.505		2.503"	2.500	2.500	2.500	2.500
H	0.510	0.515		.510"	.510	.510	.510	.511
I	1.572	1.582		1.578"	1.578	1.577	1.577	1.575
J	2.495	2.505		2.502"	2.502	2.499	2.499	2.499
K	0.257	0.262		.258"	.258	.260	.259	.259
L	0.312	0.317		.313"	.314	.314	.314	.314
M	0.235	0.240		.235"	.235	.235	.236	.237
N	0.100	0.140		.119"	.121	.121	.121	.122
O	0.540	0.560		.548"	.550	.549	.547	.545
P	0.490	0.510		.501"	.500	.500	.501	.500
Q	3.715	3.725		3.723"	3.723"	3.718	3.719	3.719
R	2.470	2.510		2.495"	2.495	2.490	2.492	2.492
S	0.240	0.270		.256"	.250	.250	.250	.250
T	0.100	0.180		.140"	.140	.140	.140	.140
U	1.625	1.635		1.630"	1.630	1.629	1.629	1.631
V	1.362	1.372		1.369"	1.369	1.368	1.367	1.366
W	0.316	0.321		.320"	.320	.321	.320	.320
X	1.125	1.145		1.132"	1.138"	1.134	1.134	1.135
Y	1.565	1.585		1.572"	1.578"	1.368	1.368	1.369
Z	0.178	0.198		.188"	.188"	.188	.188	.188
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: J.F. / On

Date: 08/08/26

Audited by: DSR 08/08/27

Date: 08/08/27

Prototype Approval:

N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	DD

DART AEROSPACE LTD			Work Order:	40281
Description: 206 Saddle, Inboard, Left side			Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:			Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.119	.120	.120	.121	.126
B	0.100	0.140		.119	.120	.120	.121	.126
C	0.100	0.140		.135	.135	.135	.136	.136
D	0.210	0.230		.218	.222	.221	.221	.221
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.510	.511	.511	.510
I	1.572	1.582		1.578	1.577	1.577	1.578	1.578
J	2.495	2.505		2.499	2.500	2.500	2.499	2.499
K	0.257	0.262		.259	.259	.259	.259	.259
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.238	.237	.237	.238	.238
N	0.100	0.140		.120	.122	.121	.122	.122
O	0.540	0.560		.545	.545	.546	.546	.546
P	0.490	0.510		.501	.501	.500	.499	.501
Q	3.715	3.725		3.717	3.717	3.719	3.716	3.717
R	2.470	2.510		2.496	2.493	2.495	2.496	2.496
S	0.240	0.270		.250	.250	.251	.251	.250
T	0.100	0.180		.140	.140	.140	.140	.140
U	1.625	1.635		1.627	1.631	1.630	1.627	1.627
V	1.362	1.372		1.367	1.368	1.366	1.368	1.368
W	0.316	0.321		.320	.326	.320	.326	.320
X	1.125	1.145		1.133	1.137	1.136	1.135	1.135
Y	1.565	1.585		1.569	1.570	1.569	1.570	1.569
Z	0.178	0.198		.188	-.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: *Onk*

Date: 08/08/26

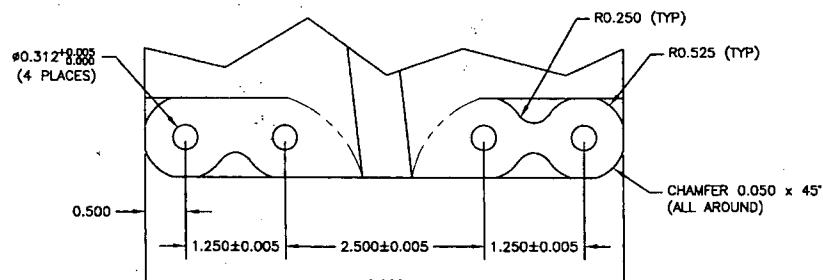
Audited by: *DAP*

Date: 08/08/27

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD <i>JK</i>	<i>JK</i>

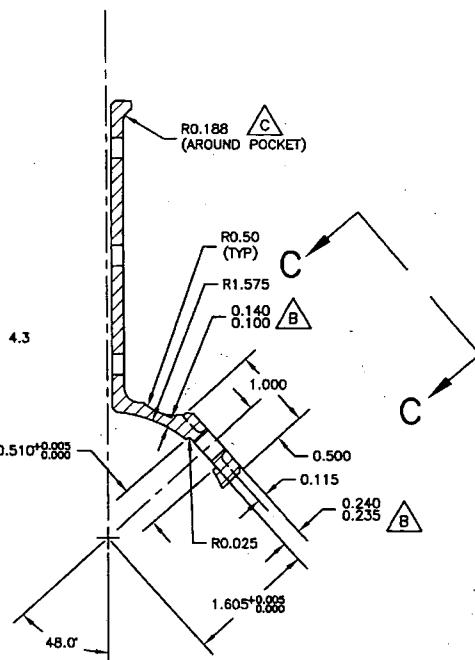


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

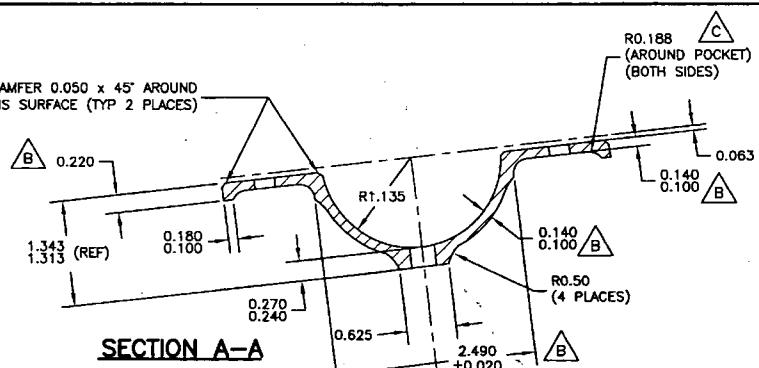
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



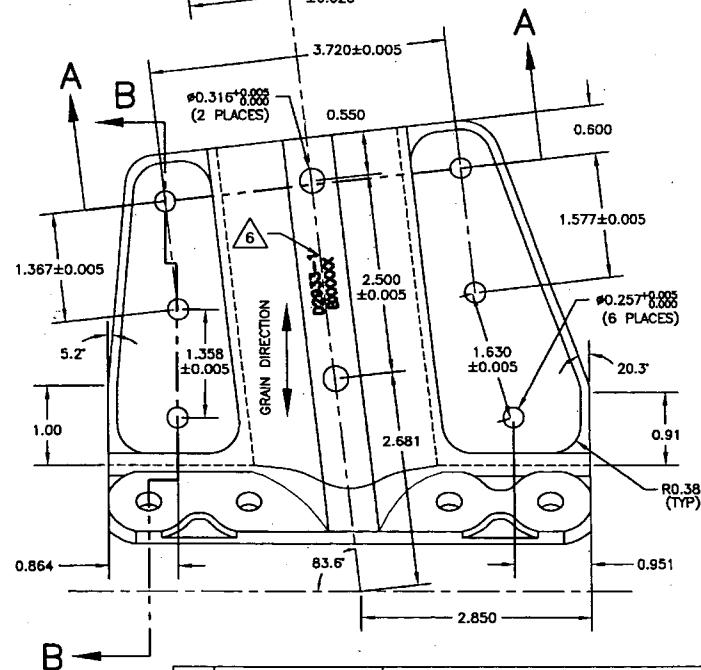
SECTION B-B

RELEASED
 07.02.12
 NO. 27028
 SHOP COPY
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

CHAMFER 0.050 x 45° AROUND
 THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30. TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A:	99.10.29	NEW ISSUE
DESIGN	CB	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	DRAWING NO. D2933 REV. C SHEET 1 OF 1
APPROVED	PH	DATE 06.11.09 TITLE SADDLE INSIDE SCALE 2:3

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